

**Work Order ID 59861**

Tuesday, June 15, 2010 10:47:26 AM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 6/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-06-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

Draw Nbr	Revision Nbr
D3836	Rev A

100



Large Fab

0.00

Large Fab

**Memo**

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open  
to finish size as per dwg D3836

SAD 10-06-17

5- weld D2327-3 spacer bushing as per dwg D3836  
A/R ER316 S.S. Rod Batch: 2. 1113328

6- grind weld flush where indicated on dwg

130



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

**Memo**

0.00

Quality Control

② PD 10-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 59861**

Tuesday, June 15, 2010 10:47:26 AM



Page 2

Item ID: D3836-041

Accept



Setup Start



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Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 6/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC5- Inspect part completeness to step on W/O

0.00

S106121

(X2)

-042

QC

Quality Control

150



Identify as per dwg &amp; Stock Location: WA

0.00

SAD  
10-06-21

(2)

Packaging

Packaging

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

0.00

10/06/23 JJ

10/10/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, June 15, 2010 10:47:30 AM

Page 1

Work Order ID: 59861



Parent Item: D3836-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/15/2010

Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3		Manufactured	No			100	Each	2.0000	1	2			
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Spacer Bushing

B58974- @ 84 10/06/21

Location	Loc Qty	Loc Code
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WA	2	
58406	2	

M304TS0.750W.065		Purchased	No			100	f	887.9497	1.7808	3.749053		
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304 SQ Tube .75x.75x.065W

340 10-06-17

Location	Loc Qty	Loc Code
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MAT	53.32232	
112398	0	
114482	53.32232	
WA	834.62738	
114520	834.62738	

3.74905

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8

7

6

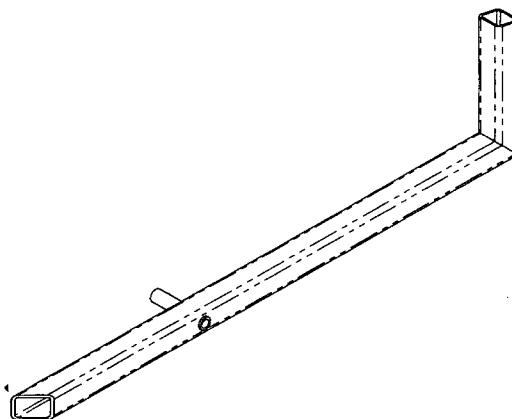
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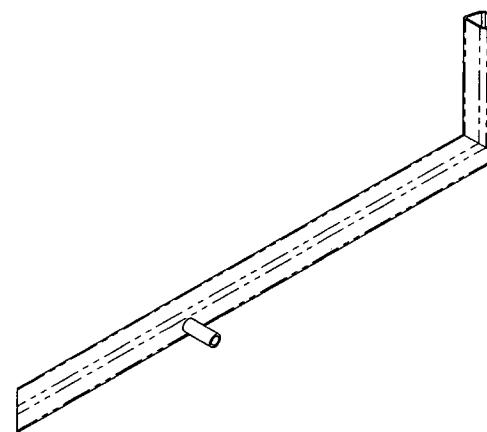
3

2

1



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

D

C

B

A

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

D

C

B

A

8

7

6

5

4

3

2

1

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59861

*BS 10-6-15*

RELEASED  
*08/11/11 MTP*

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>P-3</i>		
DRAWN			
CHECKED	<i>P-3</i>		
MFG. APPR.	<i>M</i>		
APPROVED	<i>M</i>		
DE APPR.	<i>M</i>		
DATE	08.09.24	SCALE	NTS

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3836 REV. A  
SHEET 1 OF 3

TITLE: RIB ASSY (BASKET LID)

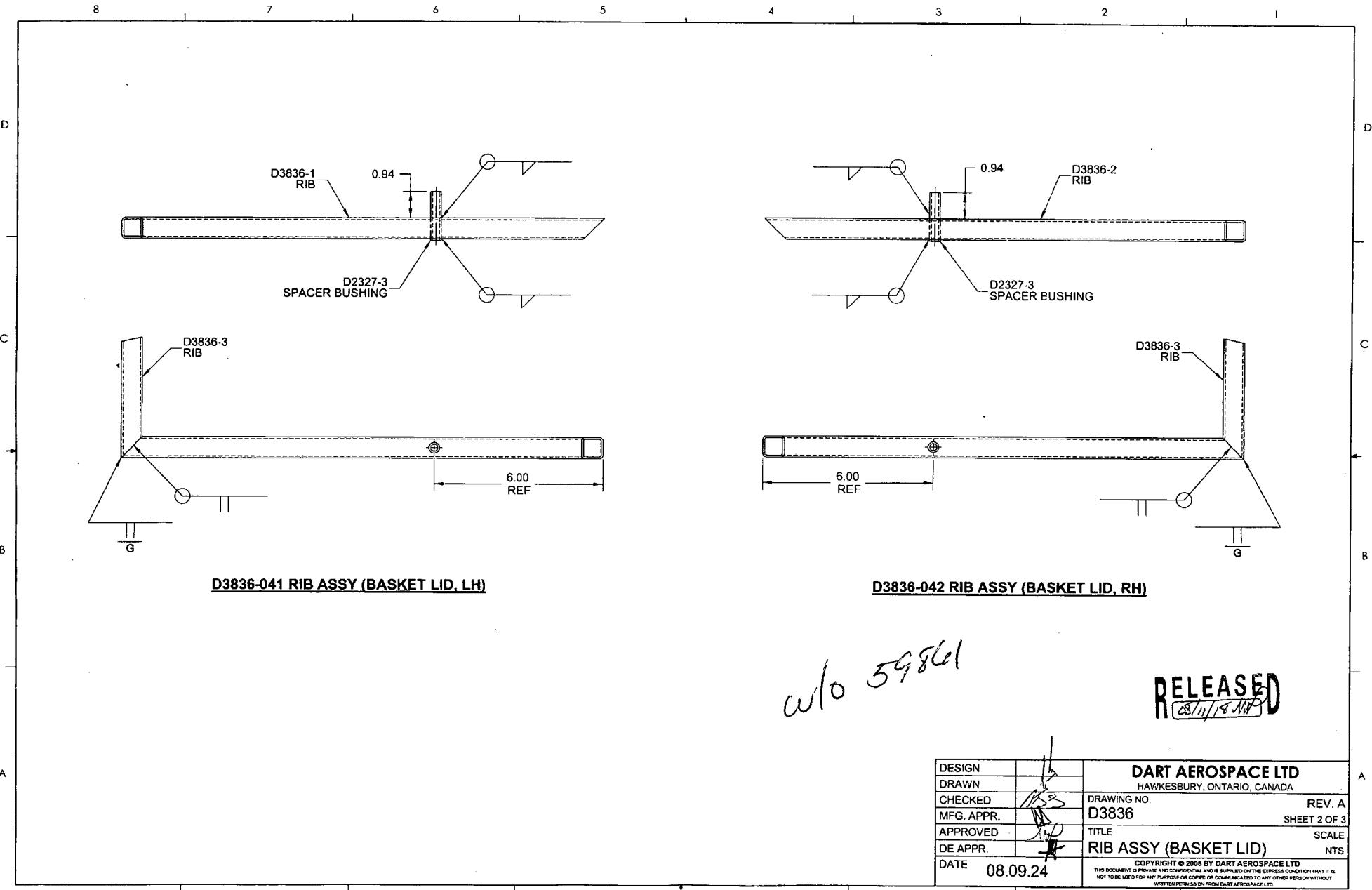
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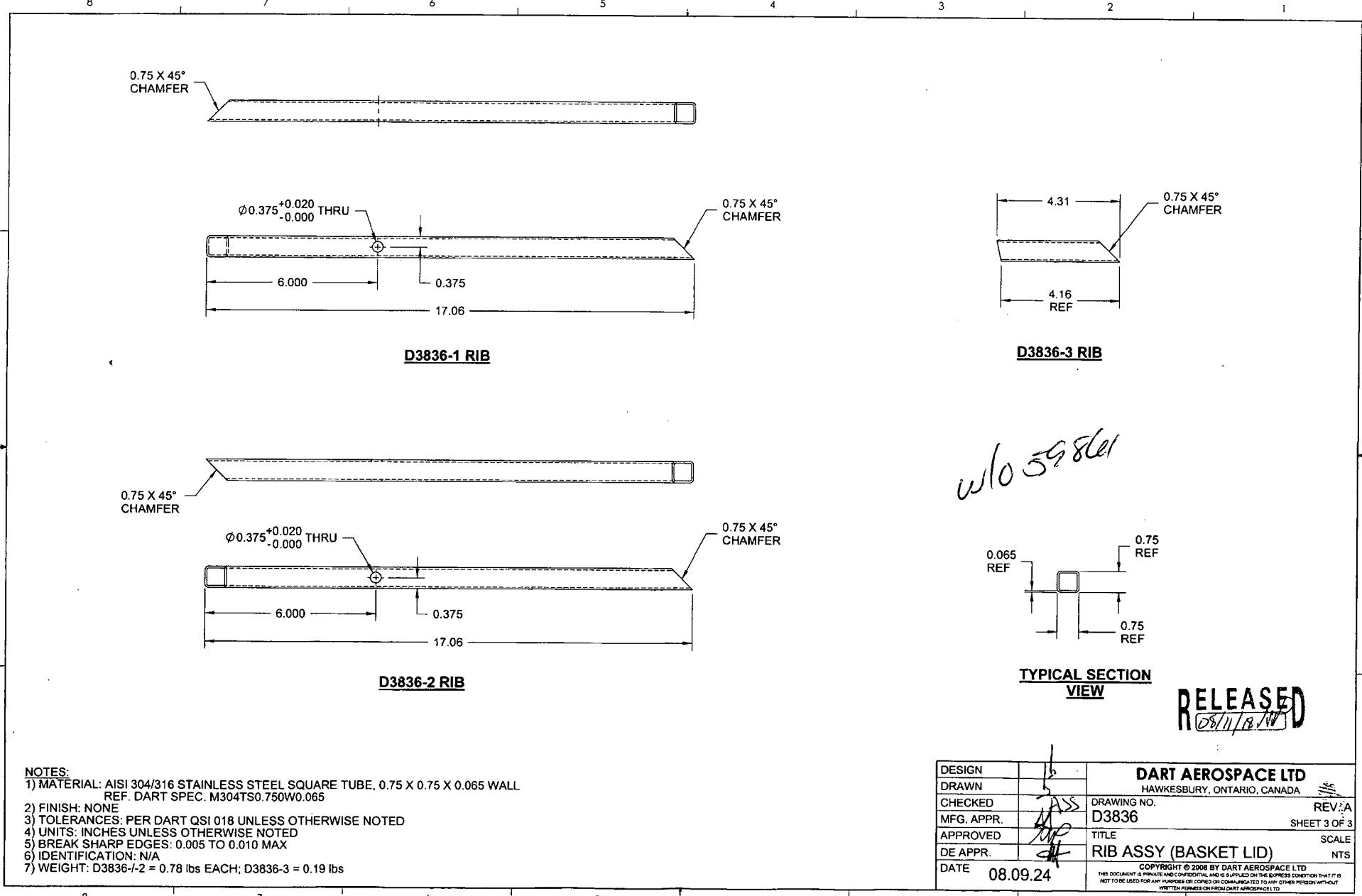
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